Claims 24-37 and 39-44 are provided without amendment for the courtesy of the Examiner.

24. The door internal element according to claim 23, further comprising cable holders (17) moulded onto the door internal element (3).

25. The door internal element according to claim 23, further comprising a mounting collar (31) for holding a loudspeaker (32), wherein said mounting collar is moulded on the door internal element.

26. The door internal element according to claim 23, further comprising a cable bushing (21).

27. The door internal element according to claim 26, wherein the cable bushing (21) has an edging (24) made of soft plastic.

28. The door internal element according to claim 23, wherein the door internal element (3) has a moulded-in bush (26).

29. The door internal element according to claim 23, wherein the door internal element (3) further comprising an inserted support plate (36) for mounting a motor (37).

30. The door internal element according to claim 29, wherein the support plate (36) is a metal plate.

31. The door internal element according to claim 23, wherein the door internal element (3) has bridges (45) which are moulded by injection-moulding thereby exposing an underside (46) of the bridges.

32. The door internal element according to claim 23, further comprising a partial wall offset (49) in the door internal element (3) for receiving a strip insert (51).

33. The door internal element according to claim 23, wherein the sealing body (12) is formed as a bead, and said bead is applied to a wide face (55) of the door internal element (3).

34. The door internal element according to claim 23, wherein the sealing body (12) is located in a

groove, said groove integrally formed in the internal door element (57).

35. The door internal element according to claim 34, wherein the groove (57) is formed by a wall offset so as to mould a foam injection-formed bead (58) on a rear side of the internal door element.

36. The door internal element according to claim 23, wherein density of the door internal element (3) varies over a cross section between 0.7 and 1.4 g/cm³ in an unfoamed boundary layer (52) and is between 0.1 and 0.6 g/cm³ in the foamed central layer (54).

37. The door internal element according to claim 23, wherein the foam injection-formed material contains a proportion of high melting strengths polymer.

39. The door internal element according to claim 23, further comprising anchoring apertures (60) provided on an end face, said anchoring apertures have a solid hole lining (61) lying in a direction of the apertures.

40. The door internal element according to claim 23, further comprising an anchoring aperture (60) surrounded by an integrally foamed tab section (62) which projects on an end face.

41. The door internal element according to claim 23, further comprising inserts such as bushes and threaded inserts, said inserts incorporated in the door internal element (3) by injection moulding therearound.

42. The door internal element according to claim 23, wherein a predetermined amount of material is removed from the door internal element (3), said predetermined amount of material extends partially through the door internal element (3), so as to provide access to the central layer (54) of lower-density.

43. The door internal element according to claim 23, wherein exposed regions of the central layer (54) serve as access for anchoring means (64).

44. The door internal element according to claim 23, further comprising clips (71) secured in the door internal element (3), wherein the position of said clips do not affect the outer skin of the internal door element.